& Rush &

Tuesday, October 14,			*125	5568*						Page 1
Revision ID:	er Plate, RH		Accept	*N900	040	100)* s	etup Sta Sto	171	S1* S2*
Start Date: 10/1 Required Date: 10/1 Reference:	4/14 Start Qty: 1.00 7/14 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					. 17
	ocess Plan:	Date: <u>\\-\D\-\</u> \	Tooling: SPC (Y/N):		nte:		R	tun Sta Sto	/\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr							****		
D3467	Rev C									
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	FLOW WATER JET Memo Cut as per	Dwg D3467 - 1 F	0.00				2		DC (4/10/15
	Dwg Rev:_ Prog Rev:_									
*110 *110* oc	QC2- Inspect parts off	machine FAI/FAIB	0.00		•		2		DC/	4/10/15
Quality Control	Memo		0.00)			/ /

DQA:		_ Date:				_							•	™ ∂ART	,
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UI		Wo	rk Order up	odate only		AEROSPACE	
Work Orde	r:				DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS			
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality	
NCR N	lo				Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	-	Other	
Root				Descr	iption of work order update		Initial	Act	ion		Sign &				-
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption		Date	Verificatio	n	QC Inspector	
Design							•								
Doc/Data															
Equip/Tooling														· ·	
Handling/Pre							٠			:					
Material			1												
Operator .		.				1									
Offset/Setup															
Process	_ .				`										
Supplier															
Training															
Transport										1					
Unapproved						L								·	
		_				FA	ULT CAT	regory							
Landir	ng Gear			_	General		,		,						
	Bending				Bend	L	Folio/F	rogram			Outside Dim	ensions		Pressure/Forced	
		lot Conce	ntric		BOM/Route	<u> </u>	Grain				Over/Under	tolerance		Set-up	
	Cracks				Broken/Damage/Defect	<u></u>	Hardwa	re		Ш	Part Incorrec	ct		Temperature/Cure	
	Crimp/Ki	ink/Ripple	e/Wave		Burrs	L	Inspect	ion Incomplete/Un	nqualified		Part Lost/Mi	ssing		Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear		Part Moved			Wrong Stock Pulled	
	Crushing	5			Countersink		Misalig	ned/off center			Positioned W	Vrong		-	
	Heat Tre	at			Cut Too Short		Mislabe	eled			Power Loss/S	Surge		Otḥer	
ļ	Inspection	on Strip in	Tube		Drawing		Misread	d	•						_
	Marks/C	hatter			Drill Holes		Off-set			_					_
	Turning 9	Sequence	!		Finish		Out of 0	Calibration		_					
	Wave/Tv	wist in Tul	be		Fit/Function		Out of	Sequence		-					_

	er ID 12550 er 14, 2014 3:40:			*125	5568*				Page 2			
Item ID: Revision ID: Item Name:	D3467-2 Cover Plate, RH			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop		
Start Date: Required Date: Reference:		eart Qty: 1.00 eq'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:						
Approvals:	Process Plan:		Date:	Tooling:	D	ate:	_		Run	Start	*NR1	k
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*NR2	k
Sequence ID/ Work Center II		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re		Reject Insp. Number Stamp)
120	QC	C8- Inspect parts - seco	ond check	0.00					`		DAS	
120 QC Quality Control		Мето		0.00				(2)	<u> </u>		38 9-89 1	1-10-15
130				0.00			DAS					.1.1
1.30 Small Fab	Sm	nall Fab		0.00			30 9-89	2				14 (v)

0.00

0.00

Small Fab

140

140

Quality Control

1-Deburr 2-Form as per dwg D3467

QC5- Inspect part completeness to step on W/O

Memo

DQA:		Date:		-		DART						
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RIMANCE / UI		ork Order uj	odate only	AEROSPACE
					DISPOSITION				AGAINST DE			
Work Orde	r:				DISPOSITION		İ		AGAINST DE	PAKTIVICIVI	/PROCESS	
Part N	0				Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0.		··- ·-		Suspected Unapproved			Large Fab	Composite	, Rec/3to	Supplier	differ
Root				Desci	ription of work order update		Initial	Acti	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Design												
Doc/Data					!							
Equip/Tooling												
Handling/Pre												
Material												
Operator												1
Offset/Setup												
Process												
Supplier	_											
Training												
Transport										İ		
Jnapproved												
						FA	ULT CAT	EGORY				
Landin	g Gear				General		_			_		
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
ļ	Centre No	ot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
1	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
Ĺ	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
	Heat Trea	it			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
Ĺ	Inspection	n Strip in	Tube		Drawing		Misread					
	Marks/Ch	atter			Drill Holes		Off-set					
Ĺ	Turning S	equence			Finish		Out of C	alibration				
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	equence				

Work Ord Tuesday, Octob				*125	5568*							Page 3
Item ID: Revision ID: Item Name:	D3467-2 Cover Plate,	, RH		Accept	*N900	040	100) * §	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	10/14/14 e: 10/17/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:	_	F	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):		ate:				Stop	*N	R2*
Sequence ID/ Work Center 150	ID	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
150 Packaging Packaging		Memo	,	0.00				_2	<u></u>	8	019	1-10
160		QC21- Final Inspection	- Work Order Release	0.00							1) , \/

0.00

Memo

1 60

Quality Control

DQA:			Date:										
						WORK ORDER NON	-CC	ONFO	RMANCE / UP			_	AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	-				_	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	۷o					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR I	No.`					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	-					Suspected Onapproved			Large ras []	composite	_	Jupplie!	
Root		· ·			Desci	ription of work order update		nitial	Actio	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspector
Design													
Doc/Data	Ш												
Equip/Tooling													
Handling/Pre	Ш					* *,							
Material						4							·
Operator							15						
Offset/Setup	Ш												
Process	Ш												
Supplier							ł						
Training					 						į		
Transport													
Unapproved													
						7.07	FAI	ULT CAT	regory				
Landi	$\overline{}$					General							_
	-	Bending			<u> </u>	Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	—	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
	$\boldsymbol{-}$	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u></u>	Inspecti	ion Incomplete/Unc	qualified	Part Lost/Mi	issing	Weld
	Щ	Cuffs				Contamination		Instruct	ions Incomplete/Ur	nclear	Part Moved		Wrong Stock Pulled
	Ш	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
	Ш	Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Ш	Inspection	n Strip in	Tube		Drawing		Misread					
•	Ш	Marks/Ch	atter			Drill Holes		Off-set					
	Ш	Turning S	equence			Finish		Out of 0	Calibration				
	1	Wave/Tw	ist in Tub)e		Fit/Function	1	Out of 9	Sequence				

. Picklist Print

Tuesday, October 14, 2014 3:40:07 PM

Work Order ID: 125568

125568

Parent Item:

D3467-2

D3467-2

Parent Item Name: Cover Plate, RH

Start Date: 10/14/14

Required Date: 10/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 13.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prin Item Loc	Rou ition Seq		Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No	100	sf	83.4000	0.736	1			
M304S26	SG A						**			0. 14	112/15

304/316 0.018 SHEET

Location	Loc Oty	Loc Code
MAT020	83.4	
122753	26	
(123135)	57.4	

DQA:			Date:										TQAR.
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPE		ork Order up	odate only	AEROSPACE
		-				DISPOSITION				AGAINST DE	·	·	
Work Orde	er: -						,				1		, , , , ,
Dowt N	\1 -					Rework			—	Crosstube		Water Jet	Engineering
Part N	NO					Scrap			Machining	Small Fab	1	d. Eng. Coor.	Quality
NCR I	۷o.					Use-as-is Suspected Unapproved		inern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
			· · · · · · · · · · · · · · · · · · ·										
Root	,				Desci	ription of work order update		nitial	Actio		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Design	Ш												
Doc/Data	$\vdash \vdash$												
Equip/Tooling	Ш												
Handling/Pre	<u> </u>	,											
Material	Щ				1								
Operator	Ш												
Offset/Setup	$\vdash \dashv$		<u> </u>										
Process	$\vdash \vdash$											•	
Supplier	\vdash												
Training _	Н											;	
Transport	Н								·				:
Unapproved								UTCAT	TECODY		<u>L</u>		
Landi	na G	Foor				General	FAL	JLI CA	regory				
Latiu		Bending			Γ	Bend		Falia/D	Program	<u> </u>	Outside Dim		Pressure/Forced
		Centre No	nt Concer	ntric		BOM/Route	\vdash	Grain	Togram		Over/Under		Set-up
	Н	Cracks	or concer	itiic	\vdash	Broken/Damage/Defect	_	Hardwa	ure.		Part Incorre	<u> </u>	Temperature/Cure
: :	Н	Crimp/Kir	nk/Rinnle	/\Maye		Burrs	<u> </u>	ł	ire ion Incomplete/Unqu	ralified	Part Lost/Mi	 	Weld
	_	Cuffs	пу пірріс	, wave		Contamination		1	tions Incomplete/Unc		Part Moved		Wrong Stock Pulled
	-	Crushing			-	Countersink	\vdash	1	gned/off center		Positioned V	<u> </u>	TANIOUS STOCK LAUGA
	╌	Heat Trea	ıt		-	Cut Too Short		Mislabe	•		Power Loss/		Other
	\vdash	Inspection		Tube		Drawing		Misread		_	1. 0.4.6. 1033/		·
	_	Marks/Ch				Drill Holes		Off-set			-		
	\vdash	Turning S				Finish		i	Calibration				
	\vdash	Wave/Tw				Fit/Function		4	Saguence				

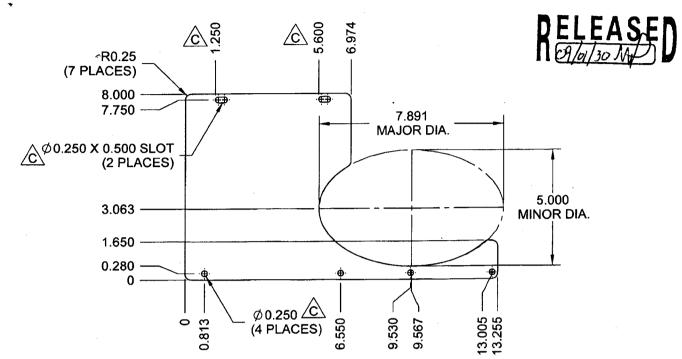
DART AEROSPACE LTD	Work Order:	125568
Description: Cover Plate, RH	Part Number:	D3467-2
Inspection Dwg: D3467 Rev: B		Page 1 of 1

	FIRS1	ARTICLE IN	ISPECTI	ON CH	ECKLIST		
	х	First Artic	cle _	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
Ø0.250 x 0. \$ 00	+0.005/-0.001	.256x503	1		V=3k4-01		
Ø0.250	+0.005/-0.001	. 250			T=Jkm-06		
0.813	+/-0.010	-813	/				
6.550	+/-0.010	6.550	/				
9.530	+/-0.010	9.530					
13.005	+/-0.010	13.005	1				
13.255	+/-0.010	13.255	/				
0.280	+/-0.010	,280	/				
1.650	+/-0.010	1.650					
7.750	+/-0.010	7.750					
8.000	+/-0.010	8.00					
1.300	+/-0.010	1.300	/	- "			
5.500	+/-0.010	5. 5 00	/				
6.974	+/-0.010	6.974					
0.018	+/-0.010	.024	7				
			DAS 38				
Measured by:	14/10/15	Audited by: Date:	9-89		Prototype Appr	oval: Date:	N/A N/A

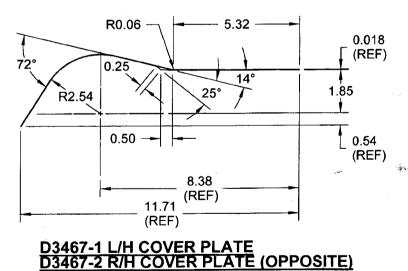
Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD	
	·	<u> </u>		

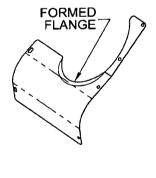


1		
DRAWN BY	DART AEROSPACI HAWKESBURY, ONTARIO, C	
APPROMED	DRAWING NO. D3467	REV. C SHEET 6 OF 15
12.19	TITLE SHROUD ASSEMBLY	SCALE 1:4
	APPROMED	HAWKESBURY, ONTARIO, O APPROVED DRAWING NO. D3467 TITLE



D3467-1F COVER PLATE FLAT PATTERN





D3467-1 L/H COVER ATE ISOMETRIC VIEW, D3467-2 R/H COVER PLATE (OPPOSITE) SCALE 1:8

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK-ALL SHARP EDGES 0.005 TO 0.010